

Work Order ID 59772

Thursday, June 10, 2010 2:47:59 PM



Page 1

Item ID: D2671

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw, 206 Narrow

Start Date: 6/10/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: HLDate: 10-6-10

Tooling:

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2671

Rev B1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per File D2671_BLANK

B1

13 10-6-11

⑧

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA790 and Dwg D2671 Identify as D2671
3-Deburr

24 10/06/13

8 6

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

24 10/06/13

2 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 59772

Thursday, June 10, 2010 2:47:59 PM



Page 2

Item ID: D2671

Accept



Setup Start



Revision ID:

Item Name: Bearpaw, 206 Narrow

Stop



Start Date: 6/10/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10.06.14 8 0

180

Identify as per dwg & Stock Location: _____
Packaging

0.00



Packaging

Memo

0.00

Packaging

PPA 527N

10/06/14 8

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/14 8
MF
10-6-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Thursday, June 10, 2010 2:48:03 PM

Page 1

Work Order ID: 59772



Parent Item: D2671



Parent Item Name: Bearpaw, 206 Narrow

Start Date: 6/10/2010

Required Date: 6/25/2010

Comments:

Start Qty: 8.00

Required Qty: 8.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MUHMWB10 | | Purchased | No | | | 120 | sf | 325.7000 | 2.7 | 21.6 | | | |



UHMW 1" Black



136-6-11

Location

Loc Qty

Loc Code

MAT

325.7

112186

20.7

113903

88

114624

217

114624

8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------|----------------|---------------------------|
| DART AEROSPACE LTD | | Work Order: 59772 |
| Description: Bearpaw | | Part Number: D2671 |
| Inspection Dwg: D2671 | Rev: B1 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|-------------|---------------------|----------|--------|-------------------------|----------|
| A | 0.063 x 45° | +0.030/-0.010 | .060 ✓ | | | |
| B | 5.500 | +/-0.030 | 5.504 ✓ | | | |
| C | 0.200 | +/-0.030 | .212 ✓ | | | |
| D | R0.250 | +/-0.030 | .250 ✓ | | | |
| E | 0.625 | +/-0.030 | .623 ✓ | | | |
| F | 0.250 | +/-0.010 | .245 ✓ | | | |
| G | 0.950 | +0.030/-0.010 | .949 ✓ | | | |
| H | 0.25 x 45° | +/-0.030 | .25 ✓ | | | |
| I | 0.375 | +/-0.010 | .382 ✓ | | | |
| J | 12.750 | +/-0.030 | 12.750 ✓ | | | |
| K | Ø0.260 | +0.005/-0.000 | .260 ✓ | | | |
| L | Ø0.93 | +/-0.030 | .927 ✓ | | | |
| M | 0.30 | +0.030/-0.000 | .314 ✓ | | | |
| N | 4.250 | +/-0.030 | 4.250 ✓ | | | |
| O | 0.375 | +/-0.030 | .375 ✓ | | | |
| P | 2.000 | +/-0.030 | 2.012 ✓ | | | |
| Q | 4.250 | +/-0.010 | 4.250 ✓ | | | |
| R | 9.000 | +/-0.010 | 9.000 ✓ | | | |
| S | 15.750 | +/-0.030 | 15.750 ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | |
|------------------------|--------------------------------|--------------------------------|
| Measured by: SP | Audited by: [Signature] | Prototype Approval: N/A |
| Date: 9/26/13 | Date: 10-06-14 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-------------------|-------------|
| A | 03.09.22 | New Issue | KJ/RF [Signature] | [Signature] |

DART

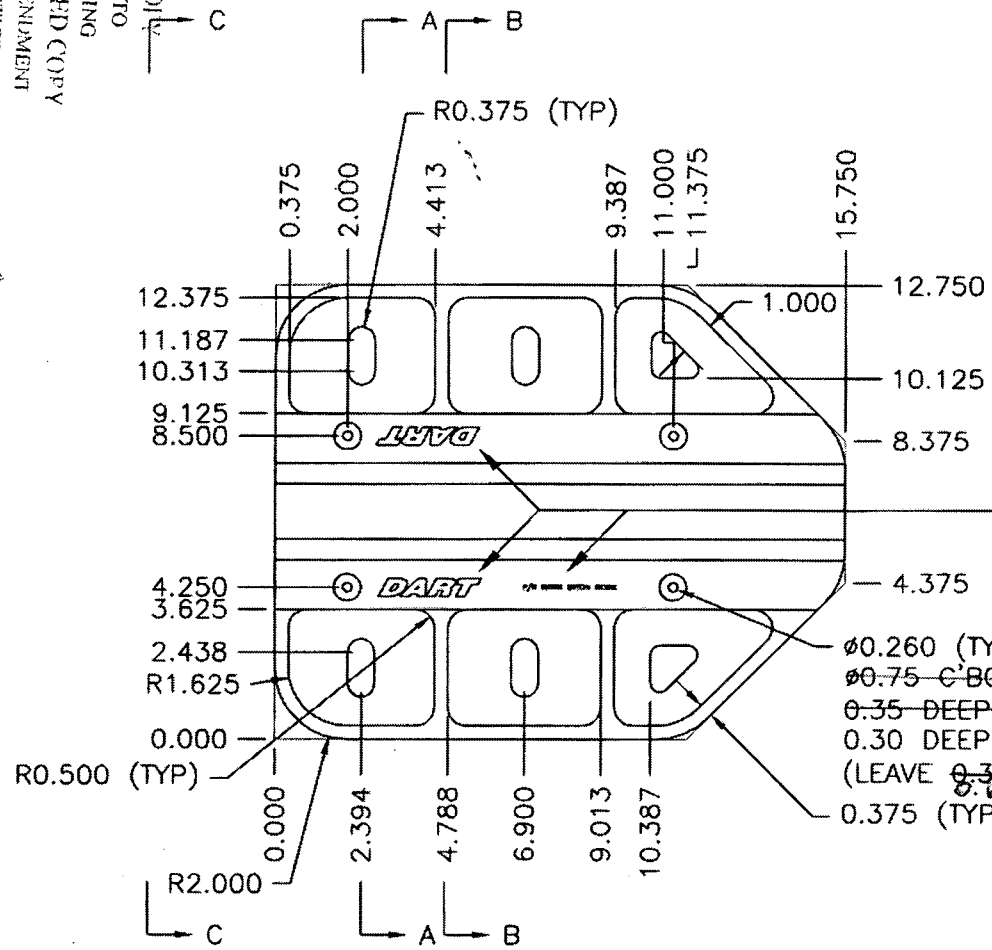


| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|-------------------|--------------------------------|-----------------------------|
| CHECKED <i>KE</i> | APPROVED <i>KE</i> | HAWKESBURY, ONTARIO, CANADA |
| DATE 98.05.19 | TITLE BEARPAW | REV. B |
| A | 97.04.08 | SHEET 1 OF 2 |
| B | 98.05.19 | SCALE 1:5 |
| | NEW ISSUE | |
| | CHANGE C'BORE, R1.58 WAS R1.50 | |

RELEASED
98.06.12 KE

| EFFECTIVE | DECS |
|-----------|------|
| 9143 | |

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 38773 Copyright 1997 by DART AEROSPACE LTD

Bf10-6-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

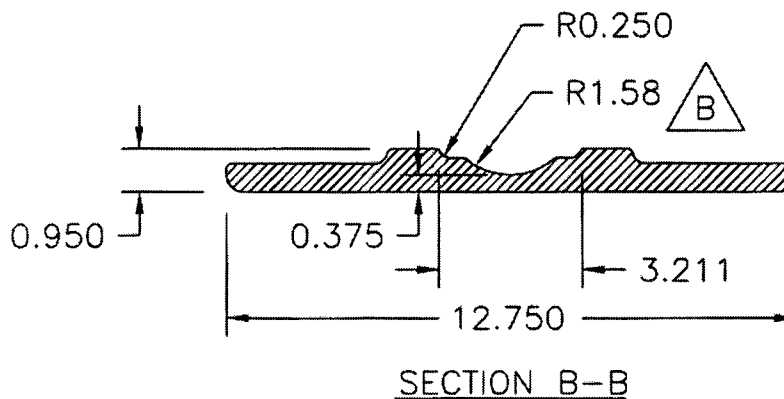
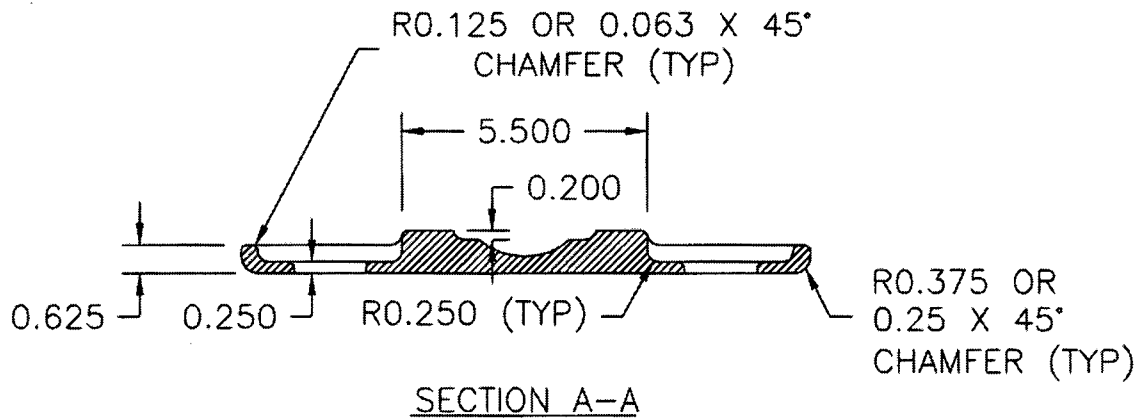
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

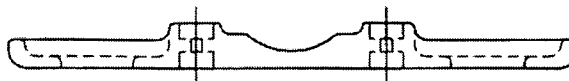


| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>KE</i> | DRAWN BY <i>KE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>DT</i> | APPROVED <i>JS</i> | DRAWING NO. D2671 | REV. B SHEET 2 OF 2 |
| DATE 98.05.19 | | TITLE BEARPAW | SCALE 1:4 |

RELEASED
99.06.17 KE



w/o 59772



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries